

Work Order ID 73305

Wednesday, August 31, 2011 10:47:00 AM



Page 1

Item ID: D3537-3

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

YMF

Date: *11-09-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 ☒ Dwg Rev: *C* ☐ Prog Rev: *C* ☐ 2-
Deburr if necessary

B11-9-14

(14)

321.063

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-14

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Seloc/14

(14)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158

SB 11/09/14

14

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Ensure joggle as per dwg D3429

Sub 14

14

150



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

Qty Description Batch A/R 2059B Hardcoat
M118807 Weld hardcoat as per Dwg D3437

14 11-09-26 JRL

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

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Page 3

Item ID: D3537-3

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Setup Start



Revision ID:

Stop



Item Name: Wearpad

Start Date: 9/1/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

8/10/26

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/26

(+14)

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

11:15

320°F

11:45

14xØ m-l 11/09/27

M118489

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

14 ϕ 11/10/27

200

Identify as per dwg & Stock Location:

F-P 2

0.00



Packaging

Memo

0.00

Packaging

14X ϕ 11/10/27

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/19/28
ME
11-09-28

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:46:56 AM

Page 1

Work Order ID: 73305



Parent Item: D3537-3



Parent Item Name: Wearpad


Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304S16GA  304/316 Sheet .063 | | Purchased | No | | | 100 | sf | 129.1000 | 0.149 | 1.568421 | | | |



B11-9-14

Location

Loc Qty

Loc Code

MAT020

116.5

118578

116.5

MAT021

12.6

118217

12.6

118578

(14)

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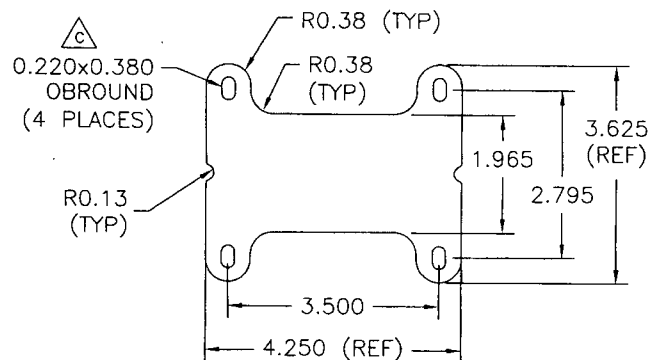
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

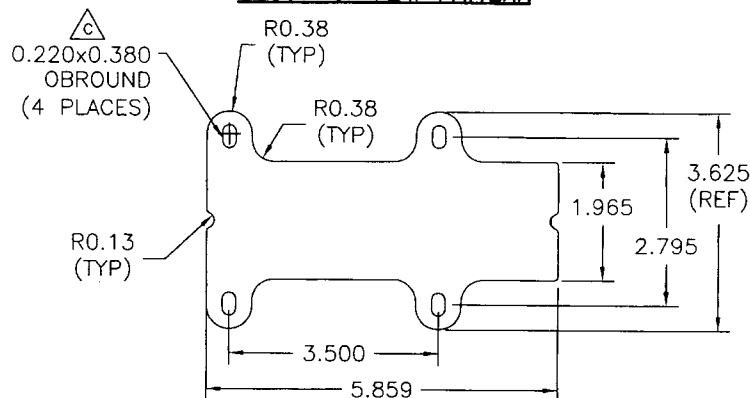
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

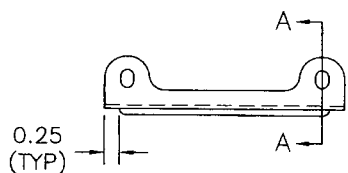
D3537-1F FLAT PATTERN



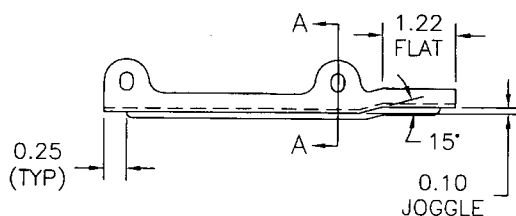
D3537-3F FLAT PATTERN



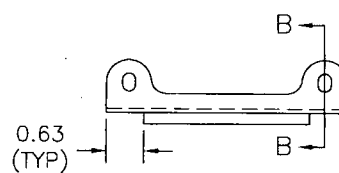
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



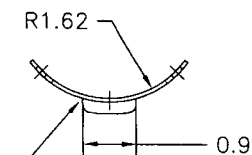
D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

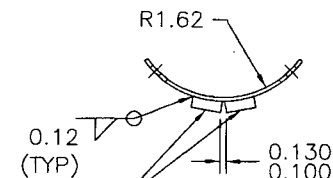
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SECTION A-A



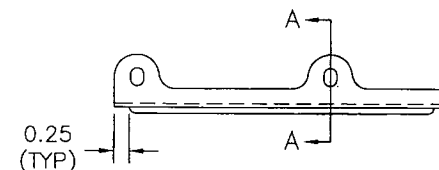
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



73305

RELEASED
07-05-08 PM
DART ECU
962

| | | |
|--------------|----------|----------------------------------|
| C | 07.04.13 | WIDEN TAB TO 0.380, WELD PATTERN |
| B | 07.03.20 | ADD AMS 5513 AND AMS 5524 |
| A | 06.11.06 | NEW ISSUE |
| DESIGN | C.B. | DRAWN BY P.H. |
| CHECKED | # | APPROVED # |
| DATE | 07.04.13 | TITLE WEARPAD |
| DRAWING NO. | D3537 | REV. C |
| SHEET 1 OF 1 | | SCALE 1:2 |

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DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

| W/O: | | WORK ORDER CHANGES | | | | | |
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